

Work Order ID 57115

March 23, 2010 7:48:32 AM

Page 1

PRELIMINARY ISSUE

Item ID: D4065-3

Accept

Revision ID:

Item Name: Aft Duct

Start Date: 3/23/10

Start Qty: 2.00

Required Date: 3/30/10

Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00

Thermoform

HAND FINISHING THERMOFORMING

Memo

0.00

Thermoforming Machine

Cut Blanks

105

HAND FINISH THERMOFORMING.

DRY SHEET AS PER QS1072.

110

0.00

Thermoform

THERMOFORMING MACHINE

Memo

0.00

Thermoforming Machine

Thermoform as per DT9581 and Dwg. D4065-3 and Folio FTA 072 □ Dwg.

Rev. FAI □ Folio Rev. A

120

0.00

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

TEMP: 250F M 10/04/06. X3
TIME IN 4:00 PM W. 10/04/06. X3
TIME OUT. 8:00 AM BB 10/04/07 X3

BB 10/04/07 X3

PTO →

BB 10/04/07 X3

BB 10/04/07 X3

| W/O: 57115 | | WORK ORDER CHANGES | | | | | | |
|------------|------|--|----|----------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| 10/04/07 | 100 | ADD SIZE 105. DAY SHEET AS PER QSI022 POLYCARBONATE. | Wh | 10/04/06 | 3 | | S 10/04/09 | |
| 10/04/07 | 100 | ADD ROUTING FROM D4065-3 & D4065-1 TO BE INCLUDED IN ROUTINGS D4065-041 | Wh | 10/04/07 | | | S 10/04/09 | |

Part No: D4065-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 57115

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Page 2

Item ID: D4065-3

Accept



Setup Start



Revision ID:

Item Name: Aft Duct

Stop



Start Date: 3/23/10

Start Qty: 2.00



Cust Item ID:

Required Date: 3/30/10

Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Thermoform

HAND FINISHING THERMOFORMING

0.00

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions

X3

Wk

10/04/08

140



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Quality Control

X5

Wk

10/04/08

150



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

Solo 16

X3

to Release New 8" Day

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Work Order ID 57115

March 23, 2010 7:48:33 AM

Page 3

Item ID: D4065-3

Revision ID:

Item Name: Aft Duct

Start Date: 3/23/10

Start Qty: 2.00

Required Date: 3/30/10

Req'd Qty: 2.00

Reference:

Accept

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: _____
Packaging

0.00

Packaging

Memo

0.00

Packaging

6/057113

OK 10/04/16 X3

170

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/04/16 JJ

u 10.04.16

POSITIVE RECALL

EFFECTIVE 10.03.13 AUTH/

RELEASED 10.04.16 DATE

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

March 23, 2010 7:48:31 AM

Page 1

Work Order ID: 57115

Parent Item: D4065-3

Parent Item Name: Aft Duct

Comments: IPP Rev:A New Issue 10/03/16 Rev A DL verified by:DD

Start Date: 3/23/10

Required Date: 3/30/10

Start Qty: 2.00

Required Qty: 2.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| MLEXS.093-F6006-02 | | Purchased | No | | | 100 | sf | 1,203.640 | 3.7500 | | | |
| GE PLASTICS LEXAN SHEET | | | | | | | | | | | | |

Warehouse

Location

Main Warehouse

MAT

Loc Qty

Loc Code

106751

1203.64

110877

6.26

1197.38

x3

OK 10/04/07

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

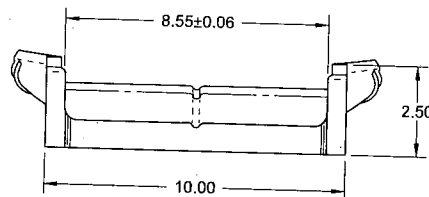
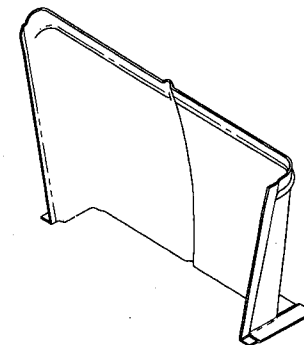
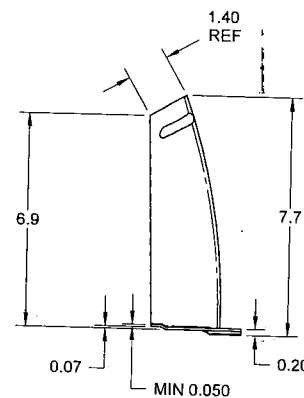
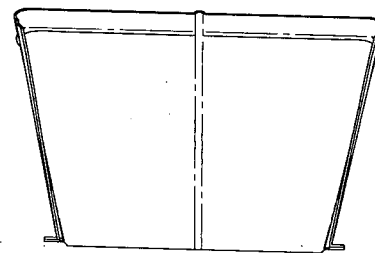
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NOTE: Date & initial all entries



W. G. H. S.

D4065-3 AFT DUCT

PRELIMINARY ISSUE

10.03.05

NOTES:

- 1) MATERIAL: LEXAN F6000 POLYCARBONATE, 0.093 THICK, SUEDE/POLISHED TEXTURE, BLACK SHEET
REF DART SPEC. MLEXS.093-F6006-02
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.38 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9581 PER QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

| | | | |
|------------|-----------------|--|--------------|
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| DRAWN | RF | | |
| CHECKED | | DRAWING NO. | REV. PA1 |
| MFG. APPR. | | D4065 | SHEET 4 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 212S DETAIL PARTS | NTS |
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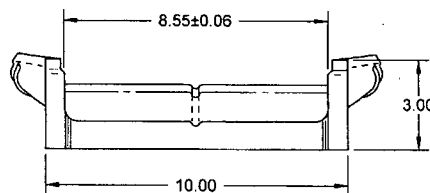
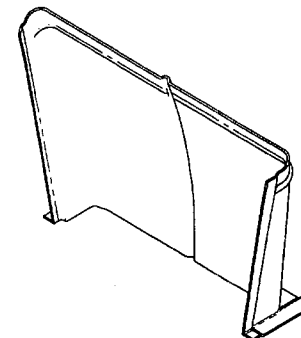
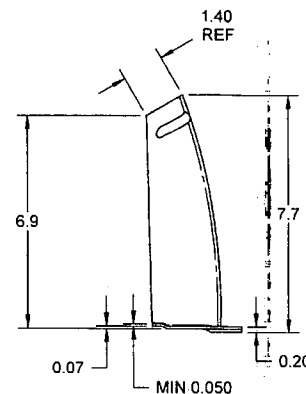
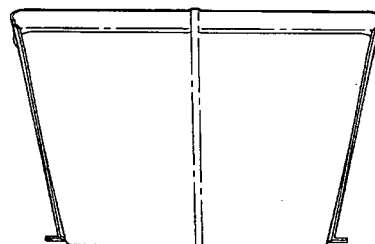
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NOTE: Date & initial all entries



REFERENCE ONLY

D4065-3 AFT DUCT

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- 1) MATERIAL: LEXAN F6000 POLYCARBONATE, 0.093 THICK, SUEDE/POLISHED TEXTURE, BLACK SHEET
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| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. A |
| MFG. APPR. | <i>[Signature]</i> | D4065 | SHEET 4 OF 4 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | DUCT ASSEMBLY | NTS |
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57115

RELEASED
2010-04-14
AMP